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## (54) AQUEOUS DISPERSIONS OF LINEAR POLYESTERS AND VINYLRESINS

WÄSSERIGE DISPERSIONEN AUS LINERAEN POLYESTERN UND VINYLHARZEN

DISPERSIONS AQUEUSES DE POLYESTERS LINEAIRES ET DE RESINES VINYLIQUES

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EP-A- 0 365 388 WO-A-92/02583

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**Description**

**Field of the Invention**

5 [0001] This invention relates to blends of water-dispersible polyesters or polyamides with styrene/ hydroxyethyl acrylate or styrene/hydroxyethyl methacrylate copolymer.

**Background of the Invention**

10 [0002] Many water-based polymer systems for water-based inks and overprint varnishes are readily coatable onto paper, plastic or metal substrates.

[0003] Such polymeric systems are disclosed in the following patents:

15 [0004] U.S. Patent 4,946,932 assigned to Eastman Kodak Company discloses water-dispersible polyester and poly-esteramide blends with certain vinyl polymers. The products are obtained via semi-batch emulsion polymerization of one or more vinyl monomers in the presence of an aqueous dispersion of a preformed water-dispersible polyester or poly-esteramide. The product is a milky latex dispersion having particle sizes in the range of 150 nm to 500 nm.

20 [0005] U.S. Patent 4,939,233 assigned to Eastman Kodak Company discloses an aqueous dispersion comprising a water-dispersible polyester or poly-esteramide and a vinyl polymer having a majority of repeat units from vinyl acetate wherein the latex polymer is formed via emulsion polymerization of the vinyl monomer in the presence of an aqueous dispersion of the polyester or poly-esteramide. However, some of these polymeric materials retain an undesirable water sensitivity when the coatings are dried. This water sensitivity can result in blocking or transfer of color if the wet surface comes in contact with another substrate. Such sensitivity can also result in total removal of the ink film from nonporous substrates such as plastic film or metal foil.

25 [0006] EP-A-0 365 388 discloses a blend of a water-dissipatable polyester material, an acrylic polymer and a water-dissipatable vinyl polymer, not a styrene polymer.

[0007] WO-A-92/02583 discloses a polymer blend comprising polyesters oder polyester amides and a styrene polymer. In particular a polymer blend is disclosed comprising:

30 (A) about 5 to about 75 weight % of at least one water-dispersible sulfonate group-containing polyester or poly-esteramide,  
(B) about 25 to about 95 weight % of a styrene polymer comprising:

(a) about 30 to about 100 weight % of repeating units from at least one styrene compound, and  
(b) up to about 70 weight % of repeating units from at least one (meth)acrylate compound.

35 [0008] Thus, it is desirable to have water-dispersible polymeric compositions which exhibit excellent dry- and wet-block resistance in overprint varnish applications and/or excellent water-resistance, adhesion and printability in ink applications.

40 **Summary of the Invention**

[0009] According to the present invention, there is provided aqueous polymer dispersions comprising:

45 (a) a polyester (A) consisting essentially of repeat units from 5 to 40% by weight of a linear, water-dissipatable polymer having carbonyloxy linking groups in the linear molecular structure wherein up to 80% of the linking groups may be carbonylamido linking groups, the polymer having an inherent viscosity of at least 0.1 measured in a 60/40 parts by weight solution of phenol/tetrachloroethane at 25°C and at a concentration of 0.25 gram of polymer in 100 ml of the solvent, the polymer containing substantially equimolar proportions of acid equivalents (100 mole percent) to hydroxy and amino equivalents (100 mole percent), the polymer comprising the reaction products of (1), (2), (3) and (4) from the following components or ester forming or esteramide forming derivatives thereof:

50 (1) at least one difunctional aromatic, saturated aliphatic or saturated alicyclic dicarboxylic acid;  
(2) from 4 to 25 mole percent, based on a total of all acid and hydroxyl equivalents being equal to 200 mole percent, of at least one difunctional sulfomonomer containing at least one metal sulfonate group attached to aromatic nucleus wherein the functional groups are hydroxy or carboxyl;  
(3) at least one difunctional reactant selected from a glycol or a mixture of a glycol and diamine having two -NRH groups, the glycol containing two -CH<sub>2</sub>-OH groups; and  
(4) from none to at least one difunctional reactant selected from a hydroxycarboxylic acid having one -CR<sub>2</sub>-

OH, an aminocarboxylic acid having one -NRH group, an amino-alcohol having one -CR<sub>2</sub>-OH group and one -NRH or mixtures thereof, wherein each R is an H atom or an alkyl group of 1 to 4 carbon atoms;

and

5 (b) 95 to 60% by weight of a polymer (B) having repeat units from

- (1) at least 20 % by weight of a polymer comprising repeat units from styrene or one or more derivatives of styrene;
- (2) 15 to 50% by weight of hydroxyalkyl (meth)acrylate or a hydroxylalkyl acrylate, with the proviso that said hydroxyalkyl methacrylate is not hydroxypropyl methacrylate; and
- (3) 20 to 60% by weight of an alkyl acrylate or an alkyl (meth)acrylate,

10 said aqueous dispersion containing 95-60% of said polymer (B) and 5-40% of said polyester (A), both said percentages being based on the combined weight of (A) and (B).

15 [0010] The invention also includes a method of preparing an aqueous polymer dispersion which comprises:

- (I) forming an aqueous dispersion having the components of Polyester (A) and Polymer (B) as described above, and
- (II) polymerizing said component b(1), b(2) and b(3) of polymer (B) monomers in said aqueous dispersion, to thereby obtain an aqueous dispersion of a blend of polymers with a total solids content of up to 60%.

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[0011] The advantages of this invention include excellent dry- and wet- block resistance in overprint varnish applications and/or excellent water-resistance, adhesion and printability in ink applications.

#### Detailed Description of the Preferred Embodiments

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[0012] The present invention provides high solids aqueous polymer compositions, sometimes referred to herein as "blends" comprising polyester (A) and polymer (B).

[0013] Polyester (A) consists essentially of repeat units from:

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(a) 5 to 40% by weight of a linear, water-dissipatable polymer having carboxyloxy linking groups in the linear molecular structure wherein up to 80% of the linking groups may be carbonylamido linking groups, the polymer having an inherent viscosity of at least 0.1 measured in a 60/40 parts by weight solution of phenol/tetrachloroethane at 25°C and at a concentration of 0.25 gram of polymer in 100 ml of the solvent, the polymer containing substantially equimolar proportions of acid equivalents (100 mole percent) to hydroxy and amino equivalents (100 mole percent), the polymer comprising the reaction products of (1), (2), (3) and (4) from the following components or ester forming or esteramide forming derivatives thereof:

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- (1) at least one difunctional aromatic, saturated aliphatic or saturated alicyclic dicarboxylic acid;
- (2) from 4 to 25 mole percent, based on a total of all acid and hydroxyl equivalents being equal to 200 mole percent, of at least one difunctional sulfomonomer containing at least one metal sulfonate group attached to aromatic nucleus wherein the functional groups are hydroxy or carboxyl;
- (3) at least one difunctional reactant selected from a glycol or a mixture of a glycol and diamine having two -NRH groups, the glycol containing two

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groups; and

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(4) from none to at least one difunctional reactant selected from a hydroxycarboxylic acid having one -CR<sub>2</sub>-OH, an aminocarboxylic acid having one -NRH group, an amino-alcohol having one



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group and one -NRH or mixtures thereof, wherein each R is an H atom or an alkyl group of 1 to 4 carbon atoms.

[0014] Preferably, the glycol of Polyester (A) of (3) above contains some poly(ethylene glycol) to aid in its water dispersibility. When some poly (ethylene glycol) is used, the content of the sulfomonomer can be lower, which aids in

flexibility of formulating the polyester.

[0015] The water dispersibility of the polyester is related to the weight percent of poly(ethylene glycol) and mole percent of sulfomonomer. Therefore, if the content of either is relatively low, the other should be relatively high to maintain adequate dispersibility.

5 [0016] The poly(ethylene glycol) need not be present in the initial reaction charge, because poly(ethylene glycol) may form in situ from decomposition products and be incorporated into the polyester chain. It is well known, for example, that diethylene glycol is formed in situ in such reactions.

[0017] It has been found that the respective concentrations of the polymeric components may be broadly 95-60% by weight of polymer (B) and 5-40% by weight of polyester (A), both said percentages being based on the combined 10 weight of (A) and (B). However, the preferred concentrations are 90-75% polymer (B) and 10-25% polyester (A).

[0018] Polymer (B) consists essentially of 95 to 60% by weight of a polymer having repeat units from

- (1) at least 20 % by weight of a polymer comprising repeat units from styrene or one or more derivatives of styrene;
- (2) 15 to 50% by weight of hydroxyalkyl (meth)acrylate or a hydroxylalkyl acrylate, with the proviso that said hydroxylalkyl methacrylate is not hydroxypropyl methacrylate; and
- (3) 20 to 60% by weight of an alkyl acrylate or an alkyl (meth)acrylate.

[0019] In the preferred form of the present invention, the polyester contains repeating units of a poly(ethylene glycol) of the formula  $H-(OCH_2-CH_2)_n-OH$  wherein n is an integer of 2 to 500. The value of n is preferably from between 2 to 20 20. The values of n and the mole percent of poly(ethylene glycol) in the polyester, if used, are adjusted such that the mole percent of poly(ethylene glycol) within the stated range is inversely proportional to the quantity of n within the stated ranges. Thus, when the mole percent is high, the value of n is low. On the other hand, if the mole percent is low, the value of n is high. It is apparent, therefore, that the weight percent (product of mole percent and molecular weight) of the poly(ethylene glycol) is an important consideration because the water dissipatability of the copolyester decreases 25 as the weight percent poly(ethylene glycol) in the copolyester decreases. For example, if the weight of poly(ethylene glycol) is too low, the water dissipatability of the copolyester may be inadequate. Furthermore, the weight percent of poly(ethylene glycol) is preferably adjusted such that it is inversely proportional to the mole percent of the difunctional sulfomonomer because the water dissipatability of the copolyester is a function of both the mole percent sulfomonomer and the weight percent polyethylene glycol.

30 [0020] Examples of suitable poly(ethylene glycols) include relatively high molecular weight polyethylene glycols, some of which are available commercially under the designation "Carbowax" (trademark), a product of Union Carbide. Diethylene glycol is also especially suitable.

[0021] Other useful glycols for preparing copolyester may consist of aliphatic, alicyclic and aralkyl glycols. Examples 35 of these glycols include ethylene glycol; propylene glycol; 1,3-propanediol; 2,4-dimethyl-2-ethylhexane 1,3-diol; 2,2-dimethyl-1,3-propanediol; 2-ethyl-2-butyl-1,3-propanediol; 2-ethyl-2-isobutyl-1,3-propanediol; 1,3-butanediol, 1,4-butanediol, 1,5-pentanediol, 1,6-hexanediol, 2,2,4-trimethyl-1,6-hexanediol; thiodiethanol, 1,2-cyclohexanedimethanol, 1,3-cyclohexandimethanol; 1,4-cyclohexandimethanol; 2,2,4,4-tetramethyl-1,3-cyclobutanediol; and p-xylylenediol.

40 [0022] The dicarboxylic acid component of the polyester are selected from aliphatic dicarboxylic acids, alicyclic dicarboxylic acids, aromatic dicarboxylic acids, or mixtures of two or more of these acids. Examples of such dicarboxylic acids, include succinic; glutaric; adipic; azelaic; sebacic; 1,4-cyclohexanedicarboxylic; phthalic; terephthalic and isophthalic acid. Terephthalic acid and isophthalic acid are preferred as the carboxylic acid component of the polyester.

[0023] It should be understood that use of the corresponding acid anhydrides, esters, and acid chlorides of these acids is included in the term "dicarboxylic acid."

45 [0024] The difunctional sulfomonomer component of the polyester may advantageously be a dicarboxylic acid or an ester thereof containing a metal sulfonate group, a glycol containing a metal sulfonate group or a hydroxy acid containing a metal sulfonate group. The metal ion of the sulfonate salt may be  $Na^+$ ,  $Li^+$ ,  $K^+$  and the like. When a monovalent alkali metal ion is used, the resulting polyesters are less readily dissipated by cold water and more readily dissipated by hot water. When a divalent or a trivalent metal ion is used the resulting polyesters are not ordinarily easily dissipated 50 by cold water but are more readily dissipated in hot water. It is possible to prepare the polyester using, for example, a sodium sulfonate salt and latex by ion-exchange replace this ion with a different ion, and thus alter the characteristics of the polymer. The difunctional monomer component may also be referred to the difunctional sulfomonomer and is further described hereinbelow.

55 [0025] Advantageous difunctional sulfomonomer components are those wherein the sulfonate salt group is attached to an aromatic acid nucleus such as benzene, naphthalene, diphenyl, oxydiphenyl, sulfonyldiphenyl or methylenediphenyl nucleus. Preferred results are obtained through the use of sulfophthalic acid, sulfoterephthalic acid, sulfoisophthalic acid, 4-sulfonaphthalene-2,7-dicarboxylic acid, and their esters.

[0026] Particularly superior results are achieved when the difunctional sulfomonomer component is 5-sodiosulfo-

sophthalic acid or its esters, and the glycol is a mixture of ethylene glycol or 1,4-cyclohexanedimethanol with diethylene glycol.

[0027] It is preferred that the polyester have repeat units from isophthalic acid, sodiosulfoisophthalic acid, diethylene glycol, and another glycol selected from at least one of ethylene glycol and 1,4-cyclohexanedimethanol, and another polymer containing at least 20% by weight of repeat units from styrene or one or more derivatives of styrene, and 15% by weight of hydroxyalkyl (meth)acrylate, with the proviso that said hydroxyalkyl methacrylate is not hydroxypropyl methacrylate.

[0028] If desired, the styrene or styrene derivative(s) and the hydroxyalkyl (meth)acrylate of Polymer B, as described herein, may be mixed with additional monomers which are copolymerizable with the styrene or styrene derivatives, hydroxyalkyl (meth)acrylate. The comonomers may be present in amounts from 0 to 60 weight percent. Polymer blends in which polymer (B) contains from 35 to 100% of a combination of the weight percents of styrene or styrene derivatives and hydroxyalkyl (meth)acrylate as described herein are preferred. The preferred total amount of comonomers is approximately 0-40 weight percent.

[0029] One class of suitable comonomers are acrylic and methacrylic esters. Acrylic and methacrylic acid esters having from 1 to 20 carbon atoms in the alcohol moiety are commercially available or can be easily prepared by known esterification processes. Preferred esters are the methyl, ethyl, butyl, 2-ethylhexyl and lauryl esters.

[0030] The acrylic and methacrylic acid esters may contain additional functional groups of the alcohol moiety, such as for example, hydroxyl, amine, halogen, ester, carboxylic acid, amide, nitrile and alkyl groups. Functionalized monomers such as blocked isocyanate acrylates and methacrylates may also be used to provide crosslinking sites for the preparation of curable systems.

[0031] Also, particularly useful as comonomers are lower alkyl diesters of unsaturated dicarboxylic acids. For example, C<sub>1-4</sub> diesters of maleic and fumaric acids, e.g., dibutyl maleate, may be used in copolymers with styrene or styrene derivatives and hydroxyalkyl (meth)acrylate or hydroxyalkylacrylate as described herein.

[0032] Other useful comonomers include acrylonitrile, acrylic acid, maleic anhydride, fumaric acid, methacrylic acid, acetoacetoxyethyl methacrylate and the corresponding acrylate, and halogenated vinyl monomers such as vinyl chloride and vinylidene chloride. These monomers may be used individually or may be used as mixtures to provide the desired properties. The preferred ratios of the various monomers can be readily determined by one skilled in the art and are dependent upon the particular application and desired properties of the water-dispersible polyester blend.

[0033] It is preferred that polymer (B) comprise repeat units from 0 to 80 weight % of one or more comonomers selected from the group consisting of ethylene, acrylic acid, methacrylic acid, acrylic and methacrylic acid esters, acrylamides, unsaturated dicarboxylic acid diesters, vinyl chloride and maleic anhydride.

[0034] It is more preferred that polymer B comprise repeat units from at least 20% by weight of one or more comonomers selected from styrene, methylmethacrylate, ethylhexylacrylate and butylacrylate.

[0035] The compositions of the present invention are prepared in aqueous dispersions. The monomers are generally added to an aqueous dispersion of the water-dispersible polyester and polymerized by free radical initiation in conventional emulsion or suspension polymerization processes. The preferred ratio of polyester to monomer in the dispersion prior to polymerization will vary widely and depends on the intended application.

[0036] The polymerization can be initiated by a watersoluble or water-dispersible free radical initiator known in the art such as sodium persulfate, or by an oil-soluble initiator such as benzoyl peroxide. Other useful initiators include redox initiators such as sodium persulfate, ammonium persulfate, sodium metabisulfite, and sodium formaldehyde sulfoxylate/Fe/hydrogen peroxide. The concentration of the initiator will generally range from 0.01% to 0.5% based on total reaction weight.

[0037] The sulfonate-group containing polyesters which are used in the present invention typically become very viscous at concentrations above the 30 percent total solids. Thus, the reaction typically is begun with a polyester dispersion that is 30 percent total solids or less. However, the water-dispersible polyester blend dispersions which are prepared by the process of the present invention can be prepared at final total solids levels up to 45 percent to 65 percent. A total solids content of 25 percent to 45 percent is preferred. The increase in solids level is achieved during polymerization by controlling the amount of water, if any, which is added along with the monomer. By decreasing the amount of water added during the polymerization, increased total solids contents up to 50 percent to 65 percent are possible. This increase in solids level offers significant benefits for the use of the water-dispersible polyesters of the present invention.

[0038] The copolymerization of the styrene and acrylate monomer(s) in the presence of water-dispersible polyester may be conducted batchwise, semi-batch or in a continuous manner.

[0039] In a preferred embodiment, the sulfonate group-containing polyester is prepared, generally by melt phase polymerization techniques which are well known in the art. The polymers as prepared may be directly dispersed in hot water or extended into rods and chopped into pellets. These pellets can later be dispersed in hot water if desired. An aqueous dispersion containing 5-35 weight %, preferably from 10 percent to 30 percent total solids, is prepared from the polyester directly. A mixture of one or more monomers and the polymerization initiators may then be added to the

aqueous dispersion of the polyester and polymerization initiated to produce an aqueous dispersion. When using a persulfate initiator, for example, the polymerizations are generally conducted at temperatures of 70°C to 90°C. Usually a small amount of initiator is added toward the end of the copolymerization in order to react as much of the styrene and hydroxyethyl (meth)acrylate or hydroxypropylacrylate monomers as possible. It is desirable to have less than 100 5 ppm of unreacted vinyl/acrylic monomer(s) in the final product and preferably less than 50 ppm unreacted monomer (s). The aqueous dispersion so produced can be prepared with total solids contents from 10 percent to 65 percent.

[0040] In another mode of operation, some of the aqueous polyester dispersion is added to the reaction vessel while the vinyl monomers and initiator are dispersed in another portion of the polyester dispersion. After heating the reaction mixture to the desired temperature, the portion containing polyester, vinyl monomers and initiator is gradually added 10 with stirring. The translucent latexes obtained have virtually no coagulum.

[0041] The aqueous dispersion of polymer prepared in this manner may be used directly as paper adhesives and coatings. Viscosity control agents, colorants, dyes, stabilizers, etc., may be added to the aqueous dispersions to prepare specific adhesives and coatings.

[0042] The total solids content of the aqueous dispersion is controlled by the relative amounts of polymers which 15 are used in the polymerization reaction and by the amount of water added during polymerization. As noted above, dispersions of sulfonate group-containing polymers can practically be prepared only at total solids contents up to 30 percent. Above 30 percent, these dispersions become highly viscous and difficult to process. Higher total solids contents can be obtained by increasing the amount of monomer and decreasing the amount of polyester which are used in the polymerization reaction.

[0043] It is preferred that the aqueous dispersion of the invention have a solid content of 25 to 45 weight %.

[0044] It is also preferred that polyester (A) (component (a)) have a solid content of from 5 to 40 weight %, preferably 10 to 30 weight %, based on dry solids.

[0045] The specific amounts of polyester (A) and polymer (B) can be chosen by one skilled in the art depending on the specific monomers, the desired total solids content and the application for which the aqueous dispersion is intended.

[0046] These blends can be formulated by those skilled in the art so that excellent wet block resistance in overprint 25 varnish applications as well as excellent printability, adhesion, and water-resistance in ink applications for paper, film and foil results. However, these properties are dependent on latex composition, particularly on the composition of the styrene/(meth)acrylate co- or terpolymer. The particle size of these aqueous polymer blends generally range from ≤300 nm, and more preferably from 40 nm to 200 nm. It is believed that the hydroxyethyl (meth)acrylate or hydroxypropyl 30 acrylate monomers are responsible for providing polymer blends with these small particle sizes. It is also believed that the hydroxyethyl (meth)acrylate or hydroxypropyl acrylate serves as a reactive cosolvent which lowers the interfacial tension between the monomer droplets and the aqueous phase, thereby lowering the monomer droplet size and consequently reducing the final particle size. The hydrophilic hydroxyethyl (meth)acrylate or hydroxypropyl acrylate may 35 also react with the hydrophobic styrene and/or (meth)acrylate monomer units to form oligomeric surfactant molecules in situ. Such an interaction would allow a low emulsion particle size to be maintained even with a reduction in the amount of the water-dispersible polyester (i.e., primary surfactant) present in the latex. Finally, the presence of the hydroxyethyl (meth)acrylate or hydroxypropyl acrylate reduces the amount of coagulum formed during latex preparation.

[0047] The dispersions or blends according to this invention may be used by applying them as a coating to a substrate 40 such as paper followed by drying to leave a residue of solids in the form of a coating.

[0048] Alternately, a second substrate can be applied prior to drying to form a bond between the substrates.

[0049] The invention also includes a method of preparing an aqueous polymer dispersion which comprises forming an aqueous dispersion having the components of polyester (A) and polymer (B) as described herein and polymerizing components b(1), b(2) and b(3) of polymer B in the aqueous dispersion, to thereby obtain an aqueous dispersion of a 45 blend of polymers with a total solids content of up to 60%.

[0050] This invention can be further illustrated by the following examples of preferred embodiments thereof, although it will be understood that these examples are included merely for purposes of illustration and are not intended to limit the scope of the invention unless otherwise specifically indicated. The starting materials are commercially available unless otherwise noted. All percentages are by weight unless otherwise noted. For the purposes of further describing 50 the following examples, Table 1 gives a description of the components of the polyesters tested.

Table 1

Polyester	TPA	IPA	SIP	EG	DEG	TEG	CHDM	NPG	I.V.	T <sub>g</sub>
A	-	89	11	-	100	-	0	-	0.42	29
B	-	89	11	-	78	-	22	-	0.36	38
C	-	82	18	-	54	-	46	-	0.33	55

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Table 1 (continued)

Polyester	TPA	IPA	SIP	EG	DEG	TEG	CHDM	NPG	I.V.	T <sub>g</sub>
D	-	89	11	28	72	-	-	-	0.42	35
E	73	16	11	50	35	15	-	-	0.46	49
F	35	50	15	24	16	9	-	51	0.25	58

TPA = terephthalic acid  
IPA = isophthalic acid  
SIP = 5-sodiosulfoisophthalic acid  
EG = ethylene glycol  
DEG = diethylene glycol  
TEG = triethylene glycol  
CHDM = 1,4-cyclohexanedimethanol  
NPG = neopentyl glycol

EXAMPLE 1

**[0051]** Items A (water, initiator), B (monomers, C (water, polyester dispersion) and D (water, polyester dispersion, sodium carbonate) listed in Table 2 below were prepared by thoroughly mixing the components of each item. Items B and D were mixed together with vigorous agitation to yield in each case a milky white pre-emulsion. Emulsion Polymer 6 is an exception to this in that no pre-emulsion was prepared; i.e., a neat monomer mixture was added to the reactor. Item C and one-tenth (1/10) of Item A were added to a reactor and heated to 85°C. The pre-emulsion from Items B and D and the remainder of Item A were simultaneously added to the reactor over a period of 150 minutes and 180 minutes, respectively. The reaction mixture was cooked for 120 minutes at 85°C after the addition of Item A was complete. The resulting latexes were cooled to room temperature and filtered through a 110 micron polyethylene mesh to remove coagulum. Latex particle size as well as the amount of coagulum formed in each reaction are presented in Table 2.

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Table 2  
Items (Components\* in grams)

Emulsion Polymer	A		B		D	Particle Diameter (microns)	g coagulum kg Latex
	H <sub>2</sub> O	APS	ST	HEMA	HEA	HPMA	HPA
1	113	0.8	180	90	—	—	—
2	113	0.8	180	—	90	—	—
3	113	0.8	180	—	—	90	—
4	113	0.8	180	—	—	—	90
5	113	0.8	150	90	—	—	—
6	113	0.8	180	90	—	—	—
7	75	0.8	217	—	—	—	—

Emulsion Polymer	C		Polyester C Dispersion (0 33% Solid)		Na <sub>2</sub> CO <sub>3</sub>	Particle Diameter (microns)	g coagulum kg Latex
	H <sub>2</sub> O	(@ 33% Solid)	H <sub>2</sub> O	Polyester C Dispersion (0 33% Solid)			
1	126	36	180	54	0.7	0.064	0.37
2	126	36	180	54	0.7	0.070	1.47
3	126	36	180	54	0.7	0.158	31.60
4	126	36	180	54	0.7	0.083	0.93
5	43	127	173	54	0.7	0.042	0.17
6	276	90	—	—	0.71	0.057	0.13
7	276	127	188	81	0.72	0.104	127

\*APS = Ammonium persulfate

ST = Styrene

HEMA = 2-Hydroxyethyl methacrylate

HEA = 2-Hydroxyethyl acrylate

HPMA = 2-Hydroxypropyl methacrylate

HPA = 2-Hydroxypropyl acrylate

1 Added to initiator solution

2 Added to pre-emulsion

EXAMPLE 2

55 [0052] Industry standard wet-block resistance tests generally involve placing an overprinted ink film face-to-face with itself and simultaneously subjecting it to water (either from the front or back of the film), pressure [0.5-1.5 psi (3.45-10.34 kPa)], and elevated temperature (55-70°C).

[0053] An overprint formulation containing 80.2 parts of the polymer latex, 6.9 parts of a polymeric film-forming ad-

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ditive, 2.7 parts surfactant, and 10.2 parts of a 30% solids polyethylene wax dispersion was coated on printed paper stock using a K Control Coater equipped with an RK1 rod (R.K. Print-Coat Instruments, Ltd.). Samples were dried in a 100°C forced-air oven for 3-5 seconds and overnight at room temperature. Gloss of the overprinted samples was measured at a 60° angle using a Lange Reflektometer. The overprinted ink films were then cut into 3" x 6" (7.62 x 15.24 cm) strips and folded in half with the coating to the inside. A drop of water was placed on the back of the sample, and the samples were separated from one another by aluminum foil. These samples were then subjected to 1 psi (6.895 kPa) at 60°C for 16 hours, at which time the printed surfaces were peeled apart and the film/paper surface evaluated. The results of gloss measurements and the wet-block resistance test are presented in Table 3.

Table 3

Emulsion Polymer #	60° Gloss (%)	Wet-Block Resistance
1	34.6	Excellent
2	42.1	Poor
3	15.9	Excellent
4	28.9	Poor
7	35.7	Fair

EXAMPLE 3

[0054] A pre-emulsion was formed from 227 g demineralized water, 0.35 g sodium carbonate, 108 g Polyester C dispersion (33% solid) and the monomers as listed in Table 3 below. An initiator solution was prepared from 75 g of demineralized water and 0.8 g of ammonium persulfate. 57 g demineralized water, 27 g of Polyester C dispersion and one-tenth (1/10) of the initiator solution were added to a reactor and heated to 75°C. The pre-emulsion and remaining initiator solution were simultaneously added to the reactor over a period of 150 minutes and 180 minutes, respectively. The reaction mixture was cooked for 120 minutes at 85°C after the addition of Item A was complete. The resulting latexes were cooled to room temperature and filtered through a 110 micron polyethylene mesh to remove coagulum. Latex particle size as well as the amount of coagulum formed in each reaction are presented in Table 4.

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Table 4

Emulsion Polymer	Monomers* (in grams)						Particle Diameter (microns)	g coagulum kg Latex
	ST	HEMA	HEA	HPMA	HPA	2EHA	BA	
8	120	60	—	—	—	—	75	0.049
9	120	60	—	—	—	—	75	0.056
10	120	—	60	—	—	—	75	0.066
11	120	—	—	60	—	—	75	0.152
12	120	—	—	—	60	—	60	0.224
13	195	60	—	—	—	—	—	0.056
14	180	—	—	—	—	—	75	0.184

\*ST = Styrene  
 HEMA = 2-Hydroxyethyl methacrylate  
 HEA = 2-Hydroxyethyl acrylate  
 HPMA = 2-Hydroxypropyl methacrylate  
 HPA = 2-Hydroxypropyl acrylate  
 2EHA = 2-Ethylhexyl acrylate  
 BA = Butyl acrylate

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EXAMPLE 4

[0055] A pigmented ink formulation containing 70.0 parts of the polymer latex, 30 parts of a pigment millbase (35% pigment), 0.5 parts surfactant and 2.0 parts of a 30% solids polyethylene wax dispersion was coated on a corona-treated polyethylene film using a K Control Coater equipped with an RK1 rod (R.K. Print-Coat Instruments, Ltd.). Samples were dried in a 100°C forced-air oven for 3 seconds and overnight at room temperature. Adhesion of the ink to the substrate was measured by placing a piece of adhesive tape on the ink film and removing the tape. The degree to which the tape removes the ink film is an indicator of adhesion to the substrate. Water-resistance of the ink films was

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measured by placing a drop of water on the printed substrate for 1, 5 and 20 minutes. After the designated time had elapsed, the water drop was wiped off using a tissue and firm pressure. Adhesion and water-resistance data are presented in Table 5.

Table 5

Example No.	Adhesion to Substrate	Water-Resistance		
		1 Minute	5 Minutes	20 Minutes
8	Very Good	Excellent	Very Good	Very Good
9	Fair	Excellent	Good	Good
10	Very Good	Fair	Poor	Poor
11	Very Good	Excellent	Poor	Poor
12	Fair	Fair	Fair	Fair
13	Poor	Excellent	Excellent	Excellent
14	Fair	Excellent	Excellent	Excellent

Similarly good results are achieved when a polyesteramide containing 82 mole % isophthalic acid, 18 mole % 5-sodiumsulfoisophthalic acid, 55 mole % diethylene glycol, 40 mole % 1,4-cyclohexanedimethanol and 5 mole % 1,4-cyclohexanebismethylamine is used instead of Polyester C.

EXAMPLE 5

[0056] This example is intended to demonstrate the diversity of water-dispersible polyesters which can be used within the scope of this invention. A stable pre-emulsion was formed from 173 g of demineralized water, 0.70 g of sodium carbonate, 60 g of a 30.0% solids aqueous dispersion of a Polyester A as described in Table 1, 180 g of styrene and 90 g of 2-hydroxyethyl methacrylate (HEMA). An initiator solution was prepared from 113 g of demineralized water and 0.8 g of ammonium persulfate. A reactor was charged with 93 g of demineralized water, 36 g of the aqueous dispersion of Polyester A and 11.3 g of the initiator solution. The reactor was heated to 85°C, at which time the pre-emulsion was added to the reactor over a period of 2.5 hours while the remaining initiator solution was added over 3 hours. After addition of the initiator solution was complete, the reaction is cooked at 85°C for two hours. The latex was cooled and filtered through a 110 micron polyethylene mesh. Using this procedure, similar latex materials were prepared using Polyesters B, D, E and F as described in Table 1. Physical characteristics of these latex materials are presented in Table 6.

Table 6

Emulsion Polymer	Polyester (Table 1)	Particle Diameter (microns)	g coagulum kg latex
15	A	0.149	7.69
16	B	0.088	0.15
17	D	0.084	0.97
18	E	0.079	0.32
19	F	0.061	0.05

Polyester E is Gerol 32 from Rhone Poulenc Chimie.  
Polyester F is XWR-905 from Nippon Goshei.

EXAMPLE 6

[0057] A stable pre-emulsion was formed from 235 g of demineralized water, 0.70 g of sodium carbonate, 54 g of a 33.2% solids dispersion of the water dispersible polyester described in Example 1, 131 g of butyl acrylate stabilized with 200-300 ppm of hydroquinone monomethyl ether and 66 g of 2-hydroxyethyl methacrylate (HEMA) stabilized with 200-300 ppm hydroquinone monomethyl ether. An initiator solution was prepared from 60 g of demineralized water and 0.8 g of ammonium persulfate. A 1-liter round bottom reactor equipped with a bottom-scraping mechanical stirrer and temperature controller was charged with 59 g of demineralized water, 144 g of aqueous polyester dispersion and 6.0 g of the initiator solution. The reactor was heated to 85°C, at which time the pre-emulsion was added to the reactor over a period of 2.5 hours while the remaining initiator solution was added over 3 hours. After addition of the initiator solution was complete, the reaction is cooked at 85° for two hours. The latex was cooled and filtered through a 110

micron polyethylene mesh to remove 0.01 g of coagulum. The light pink-to-tan translucent product contained 34.9% non-volatile matter and had a particle diameter of 125 nm.

EXAMPLE 7

5 [0058] A latex similar to that described in Example 6 was prepared, but with the omission of the HEMA monomer. An initiator solution was prepared from 60 g of demineralized water and 0.8 g of ammonium persulfate. A pre-emulsion was prepared from 54 g of a 33.2% solids aqueous dispersion of the water-dispersible polyester described in Example 1, 235 g of demineralized water, 0.7 g of sodium carbonate and 197 g of butyl acrylate. A 1-liter round bottom reactor 10 was charged with 59 g of demineralized water, 144 g of the aqueous polyester dispersion and 6.0 g of initiator solution. The detailed reaction procedure outlined in Example 1 was followed, and a milky white latex was prepared. When cooled and filtered through 110 micron polyethylene mesh, this reaction yielded 0.21 g of coagulum. The material contained 34.9% of non-volatile matter and had a particle diameter of 222 nm.

15 [0059] The invention has been described in detail with particular reference to preferred embodiments thereof, but it will be understood that variations and modifications can be effected within the spirit and scope of the invention. Moreover, all patents, patent applications (published or unpublished, foreign or domestic), literature references or other publications noted above are incorporated herein by reference for any disclosure pertinent to the practice of this invention.

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**Claims**

1. An aqueous dispersion comprising:

25 (a) a polyester (A) consisting essentially of repeat units from 5 to 40% by weight of a linear, water-dissipatable polymer having carbonyloxy linking groups in the linear molecular structure wherein up to 80% of the linking groups may be carbonylamido linking groups, the polymer having an inherent viscosity of at least 0.1 measured in a 60/40 parts by weight solution of phenol/tetrachloroethane at 25°C and at a concentration of 0.25 gram of polymer in 100 ml of the solvent, the polymer containing substantially equimolar proportions of acid equivalents (100 mole percent) to hydroxy and amino equivalents (100 mole percent), the polymer comprising the reaction products of (1), (2), (3) and (4) from the following components or ester forming or esteramide forming derivatives thereof:

35 (1) at least one difunctional aromatic, saturated aliphatic or saturated alicyclic dicarboxylic acid;  
 (2) from 4 to 25 mole percent, based on a total of all acid and hydroxyl equivalents being equal to 200 mole percent, of at least one difunctional sulfomonomer containing at least one metal sulfonate group attached to aromatic nucleus wherein the functional groups are hydroxy or carboxyl;  
 (3) at least one difunctional reactant selected from a glycol or a mixture of a glycol and diamine having two -NRH groups, the glycol containing two -CH<sub>2</sub>-OH groups; and  
 40 (4) from none to at least one difunctional reactant selected from a hydroxycarboxylic acid having one -CR<sub>2</sub>-OH, an aminocarboxylic acid having one -NRH group, an amino-alcohol having one -CR<sub>2</sub>-OH group and one -NRH or mixtures thereof, wherein each R is an H atom or an alkyl group of 1 to 4 carbon atoms;

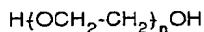
45 and

(b) 95 to 60% by weight of a polymer (B) having repeat units from

50 (1) at least 20 % by weight of a polymer comprising repeat units from styrene or one or more derivatives of styrene;  
 (2) 15 to 50% by weight of hydroxyalkyl (meth)acrylate or a hydroxylalkyl acrylate, with the proviso that said hydroxyalkyl methacrylate is not hydroxypropyl methacrylate; and  
 (3) 20 to 60% by weight of an alkyl acrylate or an alkyl (meth)acrylate,

55 said aqueous dispersion containing 95-60% of said polymer (B) and 5-40% of said polyester (A), both said percentages being based on the combined weight of (A) and (B).

2. The aqueous dispersion of claim 1 wherein said glycol containing two groups consists of at least 15 mole percent based on the total mole percent of hydroxy or hydroxy and amino equivalents, is a poly(ethylene glycol) having the structural formula:



n being an integer of between 2 to 20.

5        3. The aqueous dispersion of claim 1 wherein said component (b)(2) is present at 15-40% by weight of total solids present in said dispersion.

10      4. The aqueous dispersion of claim 3 wherein said component (b)(2) is present at 20-30% by weight of total solids present in said dispersion.

15      5. The aqueous dispersion of Claim 1 having a particle size of  $\leq 300$  nm.

20      6. The aqueous dispersion of Claim 1 having a particle size of 40 nm to 200 nm.

25      7. The aqueous dispersion of Claim 1 wherein said component (b)(2) is hydroxypropylacrylate or hydroxyethylacrylate.

30      8. The aqueous dispersion of Claim 1 wherein said component (b)(2) is 2-hydroxyethylmethacrylate.

35      9. The aqueous dispersion of Claim 1 having a solids content of 25 to 45 weight % based on total weight of said dispersion.

40      10. The aqueous dispersion of Claim 1 wherein component (a) has a solids content of from 5 to 40 weight % based on dry solids.

45      11. The aqueous dispersion of Claim 10 wherein component (a) has a solids content of from 10 to 30 weight % based on dry solids.

50      12. The aqueous dispersion of Claim 1 wherein said sulfomonomer is sodiosulfoisophthalic acid.

55      13. The aqueous dispersion of Claim 1 wherein said dicarboxylic acid comprises isophthalic acid.

60      14. The aqueous dispersion of Claim 1 wherein said glycol comprises a poly(ethylene glycol).

65      15. An aqueous dispersion of claim 1 wherein said polyester has repeat units from isophthalic acid, sodiosulfoisophthalic acid, diethylene glycol, and another glycol selected from at least one of ethylene glycol and 1,4-cyclohexandimethanol, and another polymer containing at least 20% by weight of repeat units from styrene or one or more derivatives of styrene, and at least 15% by weight of hydroxyalkyl (meth)acrylate, with the proviso that said hydroxyalkyl methacrylate is not hydroxypropyl methacrylate.

70      16. The aqueous dispersion of claim 1 wherein said polymer (B) comprises repeating units from 0 to 80 weight % of one or more comonomers selected from the group consisting of ethylene, acrylic acid, methacrylic acid, acrylic and methacrylic acid esters, acrylamides, unsaturated dicarboxylic acid diesters, vinyl chloride and maleic anhydride.

75      17. The aqueous dispersion of claim 1 wherein said polymer (B) comprises repeating units from at least 20% by weight of one or more comonomers selected from styrene, methylmethacrylate, ethylhexylacrylate and butylacrylate.

80      18. The method of preparing an aqueous polymer dispersion which comprises:

      (I) forming an aqueous dispersion having

      (a) 5 to 40% by weight of a linear, water-dissipatable polymer having carbonyloxy linking groups in the linear molecular structure wherein up to 80% of the linking groups may be carbonylamido linking groups, the polymer having an inherent viscosity of at least 0.1 measured in a 60/40 parts by weight solution of phenol/tetrachloroethane at 25°C and at a concentration of 0.25 gram of polymer in 100 ml of the solvent, the polymer containing substantially equimolar proportions of acid equivalents (100 mole percent) to hy-

droxy and amino equivalents (100 mole percent), the polymer comprising the reaction products of (1), (2), (3) and (4) from the following components or ester forming or esteramide forming derivatives thereof:

5 (1) at least one difunctional aromatic, saturated aliphatic or saturated alicyclic dicarboxylic acid;  
(2) from 4 to 25 mole percent, based on a total of all acid and hydroxyl equivalents being equal to 200 mole percent, of at least one difunctional sulfomonomer containing at least one metal sulfonate group attached to aromatic nucleus wherein the functional groups are hydroxy or carboxyl;  
10 (3) at least one difunctional reactant selected from a glycol or a mixture of a glycol and diamine having two -NRH groups, the glycol containing two -CH<sub>2</sub>-OH groups; and  
(4) from none to at least one difunctional reactant selected from a hydroxycarboxylic acid having one -CR<sub>2</sub>-OH, an aminocarboxylic acid having one -NRH group, an amino-alcohol having one -CR<sub>2</sub>-OH group and one -NRH or mixtures thereof, wherein each R is an H atom or an alkyl group of 1 to 4 carbon atoms;

15 and

(b) 95 to 60% by weight of a polymer (B) having repeat units from

20 (1) at least 20 % by weight of a polymer comprising repeat units from styrene or one or more derivatives of styrene;  
(2) 15 to 50% by weight of hydroxyalkyl (meth)acrylate or a hydroxyalkyl acrylate, with the proviso that said hydroxyalkyl (meth)acrylate is not hydroxypropyl methacrylate; and  
(3) 20 to 60% by weight of an alkyl acrylate or an alkyl (meth)acrylate,

25 (II) polymerizing said vinyl monomers in said aqueous dispersion, to thereby obtain an aqueous dispersion of a blend of polymers with a total solids content of up to 60%.

19. The method of Claim 18 wherein said sulfomonomer is sodiosulfoisophthalic acid.

20. The method of Claim 18 wherein said dicarboxylic acid comprises isophthalic acid.

21. The method of Claim 18 wherein said glycol comprises a poly(ethylene glycol).

22. The method of Claim 18 wherein said polyester has repeat units from isophthalic acid, sodiosulfoisophthalic acid, diethylene glycol, and another glycol selected from at least one of ethylene glycol and 1,4-cyclohexandimethanol, and another polymer containing at least 20% by weight of repeat units from styrene or one or more derivatives of styrene, and at least 15% by weight of hydroxyalkyl (meth)acrylate, with the proviso that said hydroxyalkyl methacrylate is not hydroxypropyl methacrylate.

23. The method of Claim 18 wherein said polymer (B) comprises repeating units from 0 to 80 weight % of one or more comonomers selected from the group consisting of ethylene, acrylic acid, methacrylic acid, acrylic and methacrylic acid esters, acrylamides, unsaturated dicarboxylic acid diesters, vinyl chloride and maleic anhydride.

24. The method of Claim 18 wherein said polymer (B) comprises repeating units from at least 20% by weight of one or more comonomers selected from styrene, methylmethacrylate, ethylhexylacrylate and butylacrylate.

25. The aqueous dispersion of Claim 1, wherein component (b)(3) comprises a C<sub>1</sub>-C<sub>20</sub> acrylic or methacrylic acid ester.

26. The aqueous dispersion of Claim 1, wherein component (b)(3) comprises methyl, ethyl, butyl, 2-ethylhexyl, or lauryl acrylic or methacrylic acid ester.

#### Patentansprüche

55 1. Wässrige Dispersion, umfassend:

(a) einen Polyester (A), bestehend im wesentlichen aus wiederkehrenden Einheiten von 5 bis 40 Gew.-% eines linearen, in Wasser dissipierbaren Polymeren mit Carboxyloxy-Verknüpfungsgruppen in der linearen

Molekülstruktur, wobei bis zu 80% der Vernüpfungsgruppen Carbonylamido-Verknüpfungsgruppen sein können, wobei das Polymer eine inhärente Viskosität von mindestens 0,1, gemessen in einer Lösung aus 60/40 Gew.-Teilen Phenol/Tetrachlorethan bei 25°C und bei einer Konzentration von 0,25 g Polymer in 100 ml des Lösungsmittels, aufweist, wobei das Polymer im wesentlichen äquimolare Verhältnisse von Säure-Äquivalenten (100 Mol-%) zu Hydroxy- und Amino-Äquivalenten (100 Mol-%) besitzt, wobei das Polymer die Reaktionsprodukte von (1), (2), (3) und (4) der folgenden Komponenten oder Ester-bildenden oder Esteramid-bildenden Derivate davon umfaßt:

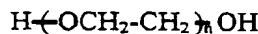
- (1) mindestens eine difunktionelle aromatische, gesättigte aliphatische oder gesättigte alicyclische Dicarbonsäure;
- (2) 4 bis 25 Mol-%, bezogen auf den gesamten 200 Mol-% entsprechenden Säure- und Hydroxyl-Äquivalenten, mindestens eines difunktionellen Sulfomonomeren, enthaltend mindestens eine an einem aromatischen Kern gebundene Metallsulfonatgruppe, wobei die funktionellen Gruppen Hydroxy oder Carboxyl sind;
- (3) mindestens einen difunktionellen Reaktanten, gewählt aus einem Glykol oder einer Mischung von einem Glykol und Diamin mit zwei -NRH-Gruppen, wobei das Glykol zwei -CH<sub>2</sub>-OH-Gruppen enthält; und
- (4) kein bis mindestens einen difunktionellen Reaktanten, gewählt aus einer Hydroxycarbonsäure mit einem -CR<sub>2</sub>-OH, einer Aminocarbonsäure mit einer -NRH-Gruppe, einem Aminoalkohol mit einer -CR<sub>2</sub>-OH-Gruppe und einem -NRH oder Mischungen davon, wobei jedes R ein H-Atom oder eine Alkylgruppe mit 1 bis 4 Kohlenstoffatomen ist; und

(b) 95 bis 60 Gew.-% eines Polymeren (B) mit wiederkehrenden Einheiten von

- (1) mindestens 20 Gew.-% eines Polymeren, umfassend wiederkehrende Einheiten aus Styrol oder einem oder mehreren Derivaten von Styrol;
- (2) 15 bis 50 Gew.-% von Hydroxyalkyl(meth)acrylat oder von einem Hydroxylalkylacrylat, mit der Maßgabe, daß das Hydroxyalkylmethacrylat nicht Hydroxypropylmethacrylat ist; und
- (3) 20 bis 60 Gew.-% eines Alkylacrylats oder eines Alkyl(meth)acrylats,

wobei die wäßrige Dispersion 95 bis 60% des Polymeren (B) und 5 bis 40% des Polyesters (A) enthält, wobei beide Prozentwerte auf das zusammengenommene Gewicht von (A) und (B) basieren.

2. Wäßrige Dispersion von Anspruch 1, wobei das zwei Gruppen enthaltende Glykol, bestehend aus mindestens 15 Mol-%, basierend auf dem Gesamt-Molprozentwert von Hydroxy- oder Hydroxy- und Amino-Äquivalenten, Poly(ethylenglykol) mit folgender Strukturformel ist:



wobei n eine ganze Zahl von 2 bis 20 ist.

3. Wäßrige Dispersion von Anspruch 1, wobei die Komponente (b)(2) zu 15 bis 40 Gew.-% der gesamten in der Dispersion vorliegenden Feststoffe vorliegt.
4. Wäßrige Dispersion von Anspruch 1, wobei die Komponente (b)(2) zu 20 bis 30 Gew.-% der gesamten in der Dispersion vorliegenden Feststoffe vorliegt.
5. Wäßrige Dispersion von Anspruch 1 mit einer Teilchengröße von  $\leq 300$  nm.
6. Wäßrige Dispersion von Anspruch 1 mit einer Teilchengröße von 40 nm bis 200 nm.
7. Wäßrige Dispersion von Anspruch 1, wobei die Komponente (b)(2) Hydroxypropylacrylat oder Hydroxyethylacrylat ist.
8. Wäßrige Dispersion von Anspruch 1, wobei die Komponente (b)(2) 2-Hydroxyethylmethacrylat ist.
9. Wäßrige Dispersion von Anspruch 1 mit einem Feststoffgehalt von 25 bis 45 Gew.-%, bezogen auf das Gesamt-

gewicht der Dispersion.

10. Wässrige Dispersion von Anspruch 1, wobei die Komponente (a) einen Feststoffgehalt von 5 bis 40 Gew.-%, bezogen auf die trockenen Feststoffe, aufweist.

5 11. Wässrige Dispersion von Anspruch 10, wobei die Komponente (a) einen Feststoffgehalt von 10 bis 30 Gew.-%, bezogen auf die trockenen Feststoffe, aufweist.

10 12. Wässrige Dispersion von Anspruch 1, wobei das Sulfomonomer Natriumsulfoisophthalsäure ist.

10 13. Wässrige Dispersion von Anspruch 1, wobei die Dicarbonsäure Isophthalsäure umfaßt.

14. Wässrige Dispersion von Anspruch 1, wobei das Glykol einen Poly(ethylenglykol) umfaßt.

15 15. Wässrige Dispersion von Anspruch 1, wobei der Polyester wiederkehrende Einheiten von Isophthalsäure, Natriumsulfoisophthalsäure, Diethylenglykol und einem anderen Glykol, gewählt von mindestens einem von Ethylen-glykol und 1,4-Cyclohexandimethanol, und einem anderen Polymer, enthaltend mindestens 20 Gew.-% an wiederkehrenden Einheiten von Styrol und einem oder mehreren der Derivate von Styrol, und mindestens 15 Gew.-% Hydroxyalkyl(meth)acrylat, aufweist, mit der Maßgabe, daß das Hydroxyalkylmethacrylat nicht Hydroxypropyl-methacrylat ist.

20 16. Wässrige Dispersion von Anspruch 1, wobei das Polymer (B) wiederkehrende Einheiten von 0 bis 80 Gew.-% von einem oder mehreren Comonomeren umfaßt, ausgewählt aus der Gruppe, die aus Ethylen, Acrylsäure, Methacrylsäure, Acryl- und Methacrylsäureestern, Acrylamiden, ungesättigten Dicarbonsäureestern, Vinylchlorid und Maleinsäureanhydrid besteht.

25 17. Wässrige Dispersion von Anspruch 1, wobei das Polymer (B) wiederkehrende Einheiten von mindestens 20 Gew.-% eines oder mehrerer Comonomeren umfaßt, ausgewählt aus Styrol, Methylmethacrylat, Ethylhexylacrylat und Butylacrylat.

30 18. Verfahren zur Herstellung einer wässrigen Dispersion, umfassend:

(I) Bilden einer wässrigen Dispersion mit

35 (a) 5 bis 40 Gew.-% eines linearen, in Wasser dissipierbaren Polymeren mit Carboxyloxy-Verknüpfungsgruppen in der linearen Molekülstruktur, wobei bis zu 80% der Vernüpfungsgruppen Carboxylamido-Verknüpfungsgruppen sein können, wobei das Polymer eine inhärente Viskosität von mindestens 0,1, gemessen in einer Lösung aus 60/40 Gew.-Teilen Phenol/Tetrachlorethan bei 25°C und bei einer Konzentration von 0,25 g Polymer in 100 ml des Lösungsmittels, aufweist, wobei das Polymer im wesentlichen äquimolare Verhältnisse von Säure-Äquivalenten (100 Mol-%) zu Hydroxy- und Amino-Äquivalenten (100 Mol-%) besitzt, wobei das Polymer die Reaktionsprodukte von (1), (2), (3) und (4) der folgenden Komponenten oder Ester-bildenden oder Esteramid-bildenden Derivate davon umfaßt:

45 (1) mindestens eine difunktionelle aromatische, gesättigte aliphatische oder gesättigte alicyclische Dicarbonsäure;

(2) 4 bis 25 Mol.-%, bezogen auf den gesamten 200 Mol.-% entsprechenden Säure- und Hydroxyl-Äquivalenten, mindestens eines difunktionellen Sulfomonomeren, enthaltend mindestens eine an einem aromatischen Kern gebundene Metallsulfonatgruppe, wobei die funktionellen Gruppen Hydroxy oder Carboxyl sind;

50 (3) mindestens eines difunktionellen Reaktanten, gewählt aus einem Glykol oder einer Mischung von einem Glykol und Diamin mit zwei -NRH-Gruppen, wobei das Glykol zwei -CH<sub>2</sub>-OH-Gruppen enthält; und

(4) kein bis mindestens einen difunktionellen Reaktanten, gewählt aus einer Hydroxycarbonsäure mit einem -CR<sub>2</sub>-OH, einer Aminocarbonsäure mit einer -NRH-Gruppe, einem Aminoalkohol mit einer -CR<sub>2</sub>-OH-Gruppe und einem -NRH oder Mischungen davon, wobei jedes R ein H-Atom oder eine Alkylgruppe mit 1 bis 4 Kohlenstoffatomen ist;

und

(b) 95 bis 60 Gew.-% eines Polymeren (B) mit wiederkehrenden Einheiten von

5 (1) mindestens 20 Gew.-% eines Polymeren, umfassend wiederkehrende Einheiten aus Styrol oder einem oder mehreren Derivaten von Styrol;  
(2) 15 bis 50 Gew.-% von Hydroxyalkyl(meth)acrylat oder von einem Hydroxylalkylacrylat, mit der Maßgabe, daß das Hydroxyalkylmethacrylat nicht Hydroxypropylmethacrylat ist; und  
(3) 20 bis 60 Gew.-% eines Alkylacrylats oder eines Alkyl(meth)acrylats,

10 (II) Polymerisieren der Vinylmonomeren in der wäßrigen Dispersion, um dadurch eine wäßrige Dispersion einer Mischung von Polymeren mit einem Feststoffgesamtgehalt von bis zu 60% zu erhalten.

15 19. Verfahren gemäß Anspruch 18, wobei das Sulfonomer Natriumsulfoisophthalsäure ist.  
20 20. Verfahren gemäß Anspruch 18, wobei die Dicarbonsäure Isophthalsäure umfaßt.  
21. Verfahren gemäß Anspruch 18, wobei das Glykol einen Poly(ethylenglykol) umfaßt.  
22. Verfahren gemäß Anspruch 18, wobei der Polyester wiederkehrende Einheiten von Isophthalsäure, Natriumsulfoisophthalsäure, Diethylenglykol und einem anderen Glykol, gewählt von mindestens einem von Ethylenglykol und 1,4-Cyclohexandimethanol, und einem anderen Polymer, enthaltend mindestens 20 Gew.-% an wiederkehrenden Einheiten von Styrol und einem oder mehreren der Derivate von Styrol, und mindestens 15 Gew.-% Hydroxyalkyl(meth)acrylat, aufweist, mit der Maßgabe, daß das Hydroxyalkylmethacrylat nicht Hydroxypropylmethacrylat ist.  
25 23. Verfahren gemäß Anspruch 18, wobei das Polymer (B) wiederkehrende Einheiten von 0 bis 80 Gew.-% von einem oder mehreren Comonomeren umfaßt, ausgewählt aus der Gruppe, die aus Ethylen, Acrylsäure, Methacrylsäure, Acryl- und Methacrylsäureestern, Acrylamiden, ungesättigten Dicarbonsäureestern, Vinylchlorid und Maleinsäureanhydrid besteht.  
30 24. Verfahren gemäß Anspruch 18, wobei das Polymer (B) wiederkehrende Einheiten von mindestens 20 Gew.-% eines oder mehrerer Comonomeren umfaßt, ausgewählt aus Styrol, Methylmethacrylat, Ethylhexylacrylat und Butylacrylat.  
35 25. Wäßrige Dispersion gemäß Anspruch 1, wobei die Komponente (b)(3) einen C<sub>1</sub>-C<sub>20</sub>-Acryl- oder Methacrylsäureester umfaßt.  
26. Wäßrige Dispersion gemäß Anspruch 1, wobei die Komponente (b)(3) Methyl-, Ethyl-, Butyl-, 2-Ethylhexyl- oder Laurylacryl- oder -methacrylsäureester umfaßt.

40 **Revendications**

1. Dispersion aqueuse de polymères comprenant :

45 (a) un polyester (A) constitué principalement de motifs répétitifs provenant de 5 à 40 % en poids d'un polymère linéaire dispersible dans l'eau ayant des groupes de liaison carboxyloxy dans la structure moléculaire linéaire, dans lequel jusqu'à 80 % des groupes de liaison peuvent être des groupes de liaison carbonylamido, le polymère ayant une viscosité inhérente d'au moins 0,1 mesurée dans une solution à 60/40 parties en poids de phénol/tétrachloroéthane à 25°C et à une concentration de 0,25 gramme de polymère dans 100 ml du solvant, le polymère contenant des proportions pratiquement équimolaires des équivalents acide (100 % en moles) aux équivalents hydroxy et amino (100 % en moles), le polymère comprenant les produits de la réaction de (1), (2), (3) et (4) à partir des composants suivants ou de leurs dérivés formant un éster ou formant un esteramide :  
50 (1) au moins un acide dicarboxylique alicyclique saturé ou aliphatique saturé aromatique difonctionnel ;  
(2) de 4 à 25 % en moles, par rapport au total de tous les équivalents acide et hydroxyle qui sont égaux à 200 % en moles, d'au moins un sulfonomère difonctionnel contenant au moins un groupe sulfonate métallique attaché au noyau aromatique, où les groupes fonctionnels sont hydroxy ou carboxyle ;

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(3) au moins un réactif difonctionnel choisi parmi un glycol ou un mélange d'un glycol et de diamine ayant deux groupes -NRH, le glycol contenant deux groupes -CH<sub>2</sub>-OH; et

(4) d'aucun à au moins un réactif difonctionnel choisi parmi un acide hydroxycarboxylique ayant un -CR<sub>2</sub>-OH, un acide aminocarboxylique ayant un groupe -NRH, un aminoalcool ayant un groupe-CR<sub>2</sub>-OH et un -NHR ou leurs mélanges, où chaque R est un atome de H ou un groupe alkyle ayant de 1 à 4 atomes de carbone ;

et

(b) 95 à 60 % en poids d'un polymère (B) ayant des motifs répétitifs provenant de

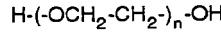
(1) au moins 20 % en poids d'un polymère comprenant des motifs répétitifs provenant de styrène ou d'un ou plusieurs dérivés de styrène ;

(2) 15 à 50 % en poids de (méth)acrylate d'hydroxyalkyle ou d'un acrylate d'hydroxyalkyle, à la condition que ledit méthacrylate d'hydroxyalkyle ne soit pas le méthacrylate d'hydroxypropyle ; et

(3) 20 à 60 % en poids d'un acrylate d'alkyle ou d'un (méth)acrylate d'alkyle,

ladite dispersion aqueuse contenant 95 à 60 % dudit polymère (B) et 5 à 40 % dudit polyester (A), lesdits deux pourcentages étant basés sur le poids combiné de (A) et (B).

2. Dispersion aqueuse selon la revendication 1, dans laquelle ledit glycol contenant deux groupes est constitué d'au moins 15 % en moles par rapport au pourcentage en moles total d'équivalents hydroxy ou hydroxy et amino, et est un polyéthylèneglycol ayant la formule structurelle :



n étant un entier entre 2 et 20.

3. Dispersion aqueuse selon la revendication 1, dans laquelle ledit composant (b)(2) est présent à raison de 15 à 40 % en poids par rapport à la teneur totale en extrait sec présent dans ladite dispersion.

4. Dispersion aqueuse selon la revendication 3, dans laquelle ledit composant (b)(2) est présent à raison de 20 à 30 % en poids par rapport à la teneur totale en extrait sec présent dans ladite dispersion.

5. Dispersion aqueuse selon la revendication 1, ayant une granulométrie de 300 nm ou moins.

6. Dispersion aqueuse selon la revendication 1, ayant une granulométrie de 40 nm à 200 nm.

7. Dispersion aqueuse selon la revendication 1, dans laquelle ledit composant (b)(2) est l'acrylate d'hydroxypropyle ou l'acrylate d'hydroxyéthyle.

8. Dispersion aqueuse selon la revendication 1, dans laquelle ledit composant (b)(2) est le méthacrylate de 2-hydroxyéthyle.

9. Dispersion aqueuse selon la revendication 1, ayant une teneur en extrait sec de 25 à 45 % en poids par rapport au poids total de ladite dispersion.

10. Dispersion aqueuse selon la revendication 1, dans laquelle le composant (a) a une teneur en extrait sec de 5 à 40 % en poids par rapport aux matières solides sèches.

11. Dispersion aqueuse selon la revendication 10, dans laquelle le composant (a) a une teneur en extrait sec de 10 à 30 % en poids par rapport aux matières solides sèches.

12. Dispersion aqueuse selon la revendication 1, dans laquelle ledit sulfuronomère est l'acide sodiosulfoisophthalique.

13. Dispersion aqueuse selon la revendication 1, dans laquelle ledit acide dicarboxylique comprend de l'acide isophthalique.

14. Dispersion aqueuse selon la revendication 1, dans laquelle ledit glycol comprend un polyéthylèneglycol.

15. Dispersion aqueuse selon la revendication 1, dans laquelle ledit polyester a des motifs répétitifs provenant d'acide isophthalique, d'acide sodiosulfoisophthalique, de diéthylèneglycol, et d'un autre glycol choisi parmi au moins l'un de l'éthylèneglycol et du 1,4-cyclohexanediméthanol, et d'un autre polymère contenant au moins 20 % en poids de motifs répétitifs provenant de styrène ou d'un ou plusieurs dérivés de styrène, et au moins 15 % en poids de (méth)acrylate d'hydroxyalkyle, à la condition que ledit méthacrylate d'hydroxyalkyle ne soit pas le méthacrylate d'hydroxypropyle.

16. Dispersion aqueuse selon la revendication 1, dans laquelle ledit polymère (B) comprend des motifs répétitifs provenant de 0 à 80 % en poids d'un ou plusieurs comonomères choisis dans le groupe constitué par l'éthylène, l'acide acrylique, l'acide méthacrylique, les esters d'acides acrylique et méthacrylique, les acrylamides, les diesters d'acides dicarboxyliques insaturés, le chlorure de vinyle et l'anhydride maléique.

17. Dispersion aqueuse selon la revendication 1, dans laquelle ledit polymère (B) comprend des motifs répétitifs provenant d'au moins 20 % en poids d'un ou plusieurs comonomères choisis parmi le styrène, le méthacrylate de méthyle, l'acrylate d'éthylhexyle et l'acrylate de butyle.

18. Procédé de préparation d'une dispersion aqueuse de polymères qui comprend :

(I) la formation d'une dispersion aqueuse ayant

(a) 5 à 40 % en poids d'un polymère linéaire dispersible dans l'eau ayant des groupes de liaison carbo-nyloxy dans la structure moléculaire linéaire, dans lequel jusqu'à 80 % des groupes de liaison peuvent être des groupes de liaison carbonylamido, le polymère ayant une viscosité inhérente d'au moins 0,1 mesurée dans une solution à 60/40 parties en poids de phénol/tétrachloroéthane à 25°C et à une concentration de 0,25 gramme de polymère dans 100 ml du solvant, le polymère contenant des proportions pratiquement équimolaires des équivalents acide (100 % en moles) aux équivalents hydroxy et amino (100 % en moles), le polymère comprenant les produits de la réaction de (1), (2), (3) et (4) à partir des composants suivants ou de leurs dérivés formant un ester ou formant un esteramide :

(1) au moins un acide dicarboxylique alicyclique saturé ou aliphatique saturé aromatique difonctionnel ;

(2) de 4 à 25 % en moles, par rapport au total de tous les équivalents acide et hydroxyle qui sont égaux à 200 % en moles, d'au moins un sulfomonomère difonctionnel contenant au moins un groupe sulfonate métallique attaché au noyau aromatique, où les groupes fonctionnels sont hydroxy ou carboxyle ;

(3) au moins un réactif difonctionnel choisi parmi un glycol ou un mélange d'un glycol et de diamine ayant deux groupes -NRH, le glycol contenant deux groupes -CH<sub>2</sub>-OH; et

(4) d'aucun à au moins un réactif difonctionnel choisi parmi un acide hydroxycarboxylique ayant un -CR<sub>2</sub>-OH, un acide aminocarboxylique ayant un groupe-NRH, un aminoalcool ayant un groupe -CR<sub>2</sub>-OH et un -NHR ou leurs mélanges, où chaque R est un atome de H ou un groupe alkyle ayant de 1 à 4 atomes de carbone ;

et

(b) 95 à 60 % en poids d'un polymère (B) ayant des motifs répétitifs provenant de

(1) au moins 20 % en poids d'un polymère comprenant des motifs répétitifs provenant de styrène ou d'un ou plusieurs dérivés de styrène ;

(2) 15 à 50 % en poids de (méth)acrylate d'hydroxyalkyle ou d'un acrylate d'hydroxyalkyle, à la condition que ledit méthacrylate d'hydroxyalkyle ne soit pas le méthacrylate d'hydroxypropyle ; et

(3) 20 à 60 % en poids d'un acrylate d'alkyle ou d'un (méth)acrylate d'alkyle,

(II) la polymérisation desdits monomères vinyliques dans ladite dispersion aqueuse, de façon à obtenir ainsi une dispersion aqueuse d'un mélange de polymères ayant une teneur totale en extrait sec allant jusqu'à 60 %.

19. Procédé selon la revendication 18, dans lequel ledit sulfomonomère est l'acide sodiosulfoisophthalique.

20. Procédé selon la revendication 18, dans lequel ledit acide dicarboxylique comprend de l'acide isophthalique.

21. Procédé selon la revendication 18, dans lequel ledit glycol comprend un polyéthylèneglycol.

5 22. Procédé selon la revendication 18, dans lequel ledit polyester a des motifs répétitifs provenant d'acide isophthalique, d'acide sodiosulfosophtalique, de diéthylèneglycol, et d'un autre glycol choisi parmi au moins l'un de l'éthylène-glycol et du 1,4-cyclohexanediméthanol, et d'un autre polymère contenant au moins 20 % en poids de motifs répétitifs provenant de styrène ou d'un ou plusieurs dérivés de styrène, et au moins 15 % en poids de (méth)acrylate d'hydroxyalkyle, à la condition que ledit méthacrylate d'hydroxyalkyle ne soit pas le méthacrylate d'hydroxypropyle.

10 23. Procédé selon la revendication 18, dans lequel ledit polymère (B) comprend des motifs répétitifs provenant de 0 à 80 % en poids d'un ou plusieurs comonomères choisis dans le groupe constitué par l'éthylène, l'acide acrylique, l'acide méthacrylique, les esters d'acides acrylique et méthacrylique, les acrylamides, les diesters d'acides dicarboxyliques insaturés, le chlorure de vinyle et l'anhydride maléique.

15 24. Procédé selon la revendication 18, dans lequel ledit polymère (B) comprend des motifs répétitifs provenant d'au moins 20 % en poids d'un ou plusieurs comonomères choisis parmi le styrène, le méthacrylate de méthyle, l'acrylate d'éthylhexyle et l'acrylate de butyle.

20 25. Dispersion aqueuse selon la revendication 1, dans laquelle le composant (b)(3) comprend un ester d'acide acrylique ou méthacrylique en C<sub>1</sub> à C<sub>20</sub>.

25 26. Dispersion aqueuse selon la revendication 1, dans laquelle le composant (b)(3) comprend de l'ester méthylique, éthylique, butylique, 2-éthylhexylique ou laurylique d'acide acrylique ou méthacrylique.

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